

Date: Monday, 07/04/2008 2:30:13 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FUEL PURGE CANISTER
<b>Job Number</b>	: 38446B		
<b>Estimate Number</b>	: 10442		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D32623
<b>This Issue</b>	: 07/04/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3262 REV C
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 37369B	<b>Drawing Revision</b>	: C
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/04/2008
<b>Checked &amp; Approved By</b>	: <u>JLD 08.4.06</u>	<b>Qty:</b>	8 Um: Each
<b>Comment</b>	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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**Comment:** Qty.: 0.9668 f(s)/Unit Total: 7.7347 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick  
 (M6061T6B0.500x06.000)  
 Identify for D3262-3  
 Batch: B07244

ml 08/05/16

8

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blanks: 6.000" x 0.500" x 5.400" long Bar  
 Machine as per Folio FA457 and Dwg D3262  
 Identify for D3262-3  
 Deburr

ml 08/05/16

8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per dwg D3262

JL/ml 08/05/16

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/05/17

8

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 38446B

Part Number: D32623

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

LS 08/05/17 (K)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST174

LS 08/05/21 (XS)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22

Job Completion



mf 08-05-21

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38446B
<b>Description:</b> Cap		<b>Part Number:</b> D3262-3
<b>Inspection Dwg:</b> D3262	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	0.072 x 45°	✓			
0.45	+/-0.030	.455	✓			
R0.063	+/-0.010	.063	✓			
0.080	+/-0.010	0.079	✓			
0.33	+/-0.030	.325	✓			
Ø5.005	+0.010/-0.000	5.005	✓			
0.688	+0.015/-0.000	.692	✓			
3.25	+/-0.005	3.250	✓			
0.875	+/-0.010	.875	✓			
Ø0.516	+0.005/-0.000	.520	✓			
Ø5.165	+/-0.010					
0.083	+0.015/-0.000	.092	✓			
Ø0.580	+0.005/-0.000	.580	✓			

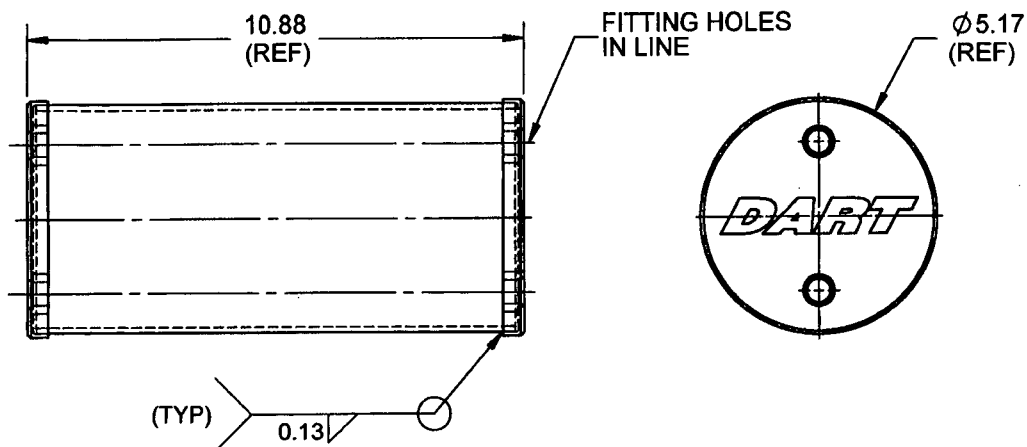
<b>Measured by:</b> J.L.	<b>Audited by:</b> S.S.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/05/17	<b>Date:</b> 08/05/17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM	BE



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø 5.165 WAS Ø 5.190	

RELEASED  
06.09.19 *[Signature]*

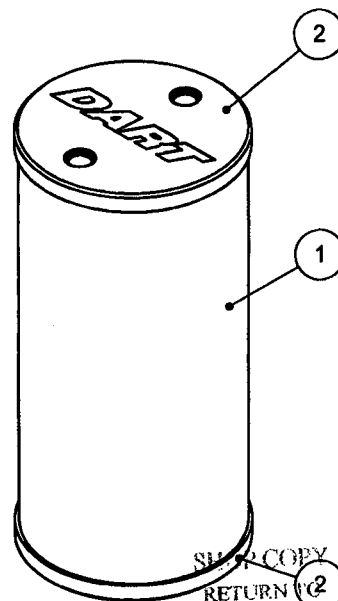


### D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



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WITHOUT NOTICE  
WORK ORDER  
38440B

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3262-3 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: LD Date: 08/05/22  
 QA: N/C Closed: A Date: 08/05/22

NCR: <u>38446B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/05/16</u>	<u>3</u>	<u>1 piece scrap the chamber</u> <u>2.688 too big of .050</u> <u>LC chamber tool wasn't</u> <u>given enough of an offset</u> <u>by the operator on his set-up</u>	<u>[Signature]</u> <u>08/05/22</u>	<u>Scrap and Destroy</u> <u>and</u> <u>replace QTY @</u> <u>B# 107244</u>	<u>[Signature]</u> <u>08/05/16</u>	<u>[Signature]</u> <u>08/05/20</u>	<u>[Signature]</u> <u>08/05/22</u>	<u>[Signature]</u> <u>08/05/20</u>
				<u>Modify program to fix the tool</u> <u>depth. see attached</u>	<u>[Signature]</u> <u>08-05-20</u>			

NOTE: Date & initial all entries

N426 (MACHINE CHAMFER)

N427 (T17-1/2" 45DEG CHAMFER TOOL)

N428 T17 M6

N429 G0 G90 G54 X5.9185 Y2.8875 S4000 M3

*New*

N430 G43 Z0.9 H17 M8

N431 G0 Z0.099

*x.050"*

N432 G1 Z-0.101 F10.0

N433 G3 X5.731 Y2.7 I0 J-0.1875

N434 G2 I-2.731 J0 F20.0

N435 G3 X5.9185 Y2.5125 I0.1875 J0 F10.0

N436 G0 Z0.9

N437 Y2.8875

N438 Z0.099

N439 G1 Z-0.101

N440 G3 X5.731 Y2.7 I0 J-0.1875

N441 G2 I-2.731 J0 F20.0

N442 G3 X5.9185 Y2.5125 I0.1875 J0 F10.0

N443 G0 Z0.9

N444 G0 G49 G90 Z0 M9

N445 G28 G91 Y0 Z0

N446 M30

%

N410 G0 Z1.5  
(ROUGH CONTOUR)  
(T3-1/2" ISCAR ROUGHER .250" DEEP) *OID*  
N411 T3 M06  
N412 S10000 M03  
N413 M08  
N414 G0 G54 X6.28 Y3.075  
N415 G43 H03 Z1.  
N416 Z.07  
N417 G1 Z-.28 F15.  
N418 G3 X5.905 Y2.7 I0. J-.375  
N419 G2 X5.905 Y2.7 I-2.905 J0. F65.  
N420 G3 X6.28 Y2.325 I.375 J0. F15.  
N421 G0 Z1.  
(MACHINE CHAMFER)  
(T17-1/2" 45DEG CHAMFER TOOL)  
N422 T17 M06  
N423 S4000 M03  
N424 M08  
N425 G0 G54 X5.9185 Y2.8875  
N426 G43 H17 Z.9  
N427 Z.049  
N428 G1 Z-.151 F10.  
N429 G3 X5.731 Y2.7 I0. J-.1875  
N430 G2 X5.731 Y2.7 I-2.731 J0. F20.  
N431 G3 X5.9185 Y2.5125 I.1875 J0. F10.  
N432 G0 Z.9  
N433 Y2.8875  
N434 Z.049  
N435 G1 Z-.151  
N436 G3 X5.731 Y2.7 I0. J-.1875  
N437 G2 X5.731 Y2.7 I-2.731 J0. F20.  
N438 G3 X5.9185 Y2.5125 I.1875 J0. F10.  
N439 G0 Z.9  
G00 G49 G90 Z0.0 M9  
G28 G91 Y0.0 Z0.0  
M30